

Work Order ID 103402

103402

Page 1

June-24-13 1:54:52 PM

Item ID: D3912-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: EYEBOLT RECEIVER ASSY

Start Date: 6/24/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/05/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-06-27 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3912	B
-------	---

100 Pick Kit 0.00

100

Packaging

Packaging

110 0.00

110

Small Fab

Small Fab

Memo 0.00

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

120 QC5- Inspect part completeness to step on W/O 0.00

DAS

27

9-89

120

QC

Quality Control

Memo 0.00

B 10 10

4x 13/10/09

4x 13/10/09

4

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS																																						
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>																																				
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																																		
Design <input type="checkbox"/>	Doc/Data <input type="checkbox"/>	Equip/Tooling <input type="checkbox"/>	Handling/Pre <input type="checkbox"/>	Material <input type="checkbox"/>	Operator <input type="checkbox"/>	Offset/Setup <input type="checkbox"/>	Process <input type="checkbox"/>	Supplier <input type="checkbox"/>	Training <input type="checkbox"/>	Transport <input type="checkbox"/>	Unapproved <input type="checkbox"/>																																	
FAULT CATEGORY																																												
Landing Gear				General																																								
Bending <input type="checkbox"/>	Centre Not Concentric <input type="checkbox"/>	Cracks <input type="checkbox"/>	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Cuffs <input type="checkbox"/>	Crushing <input type="checkbox"/>	Heat Treat <input type="checkbox"/>	Inspection Strip in Tube <input type="checkbox"/>	Marks/Chatter <input type="checkbox"/>	Turning Sequence <input type="checkbox"/>	Wave/Twist in Tube <input type="checkbox"/>	Bend <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Burrs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Countersink <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Drawing <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Finish <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Grain <input type="checkbox"/>	Hardware <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Misread <input type="checkbox"/>	Off-set <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Pressure/Forced Set-up <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	Weld <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	Other <input type="checkbox"/>

Work Order ID 103402

103402

Page 2

June-24-13 1:54:52 PM

Item ID: D3912-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: EYEBOLT RECEIVER ASSY

Stop

NS2

Start Date: 6/24/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/05/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: STO72

0.00

170

Packaging

Packaging

4x

DAS

28

9-89

13-10-10

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Quality Control

Memo

0.00

13/10/10

MF
13-10-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved	AGAINST DEPARTMENT/PROCESS <input type="checkbox"/> Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other
---	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General									
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced						
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up						
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure						
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld						
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled						
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge							
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread								
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set								
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration								
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence								

Picklist Print

June-24-13 1:54:51 PM

Page 1

62

Work Order ID: 103402

Parent Item: D3912-041

Start Date: 6/24/13

Required Date: 7/05/13

Parent Item Name: EYEBOLT RECEIVER ASSY

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B 10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R Washer		Purchased	No				Each	92.0000		4	3	3/10/09	
D3912-1 Eyebolt		Manufactured	No				Loc Qty		Loc Code				
				<u>Location</u>									
				ST292			92				4		
				116893			42						
				m125807			50						
							100	Each	23.0000	1	4	3/10/09	
D3912-3 Eyebolt Block		Manufactured	No				Loc Qty		Loc Code				
				<u>Location</u>									
				ST144			23				3	3/10/09	
				100274			20						
				77073			2						
				93713			1						
							100	Each	29.0000	2	8	3/10/09	
D3912-5 Eyebolt Plate		Manufactured	No				Loc Qty		Loc Code				
				<u>Location</u>									
				ST144			29						
				100336			8						
				88265			7						
				91865			2						
				97689			12						
							100	Each	16.0000	2	8	3/10/09	
				<u>Location</u>			Loc Qty		Loc Code				
				ST144			16						
				100421			15						
				83367			1						

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

FAULT CATEGORY

Landing Gear	General			
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
Crushing	Countersink	Misaligned/off center	Positioned Wrong	
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	
Inspection Strip in Tube	Drawing	Misread		Other
Marks/Chatter	Drill Holes	Off-set		
Turning Sequence	Finish	Out of Calibration		
Wave/Twist in Tube	Fit/Function	Out of Sequence		

Picklist Print

Page 2

June-24-13 1:54:52 PM

Work Order ID: 103402

Parent Item: D3912-041

Parent Item Name: EYEBOLT RECEIVER ASSY

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 4.00

Required Qty: 4.00

D3801-1

Manufactured

No

Each

23.0000

4

HAND RETRACTABLE SPRING PLUNGER

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	GA	20	
	100407	20	
	ST066	3	
	99271	3	

MS20615-4M20

Purchased

No

100

Each

243.0000

8

RIVET

32

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	GA	243	
	125567	243	

MS21209-F615

Purchased

No

Each

83.0000

Heli-Coil

4

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	GA	83	
	121561	2	
	125097	81	

4

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

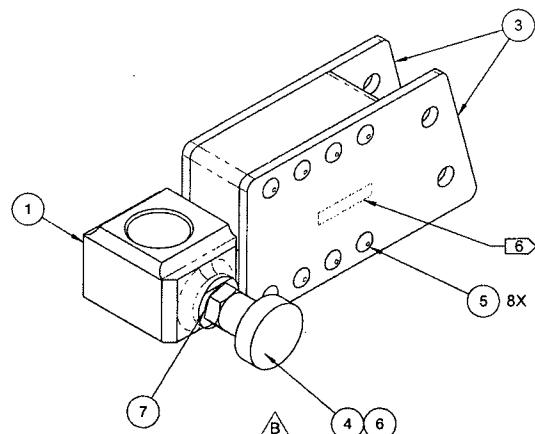
QA Closed: _____ Date: _____

Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>		
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>		Quality <input type="checkbox"/>		
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>		
				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend <input type="checkbox"/>		Folio/Program <input type="checkbox"/>		Outside Dimensions <input type="checkbox"/>		Pressure/Forced <input type="checkbox"/>			
Centre Not Concentric		BOM/Route <input type="checkbox"/>		Grain <input type="checkbox"/>		Over/Under tolerance <input type="checkbox"/>		Set-up <input type="checkbox"/>			
Cracks		Broken/Damage/Defect <input type="checkbox"/>		Hardware <input type="checkbox"/>		Part Incorrect <input type="checkbox"/>		Temperature/Cure <input type="checkbox"/>			
Crimp/Kink/Ripple/Wave		Burrs <input type="checkbox"/>		Inspection Incomplete/Unqualified <input type="checkbox"/>		Part Lost/Missing <input type="checkbox"/>		Weld <input type="checkbox"/>			
Cuffs		Contamination <input type="checkbox"/>		Instructions Incomplete/Unclear <input type="checkbox"/>		Part Moved <input type="checkbox"/>		Wrong Stock Pulled <input type="checkbox"/>			
Crushing		Countersink <input type="checkbox"/>		Misaligned/off center <input type="checkbox"/>		Positioned Wrong <input type="checkbox"/>					
Heat Treat		Cut Too Short <input type="checkbox"/>		Mislabeled <input type="checkbox"/>		Power Loss/Surge <input type="checkbox"/>					
Inspection Strip in Tube		Drawing <input type="checkbox"/>		Misread <input type="checkbox"/>				Other <input type="checkbox"/>			
Marks/Chatter		Drill Holes <input type="checkbox"/>		Off-set <input type="checkbox"/>							
Turning Sequence		Finish <input type="checkbox"/>		Out of Calibration <input type="checkbox"/>							
Wave/Twist in Tube		Fit/Function <input type="checkbox"/>		Out of Sequence <input type="checkbox"/>							

ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER

B



SHOW C

R. F. R.

ENCLURE

UNCONTRACTED

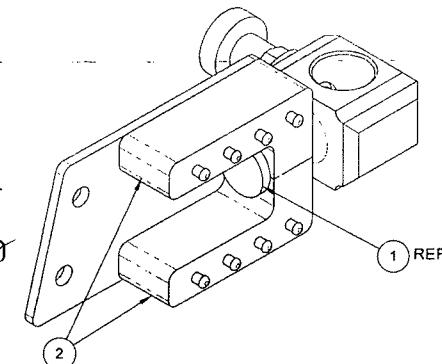
SUBJECT TO CONTRACT

WITHDRAWN

WORN OUT

NO. 103402 MJS

13-06-27



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

RELEASED
2010-07-16
W

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

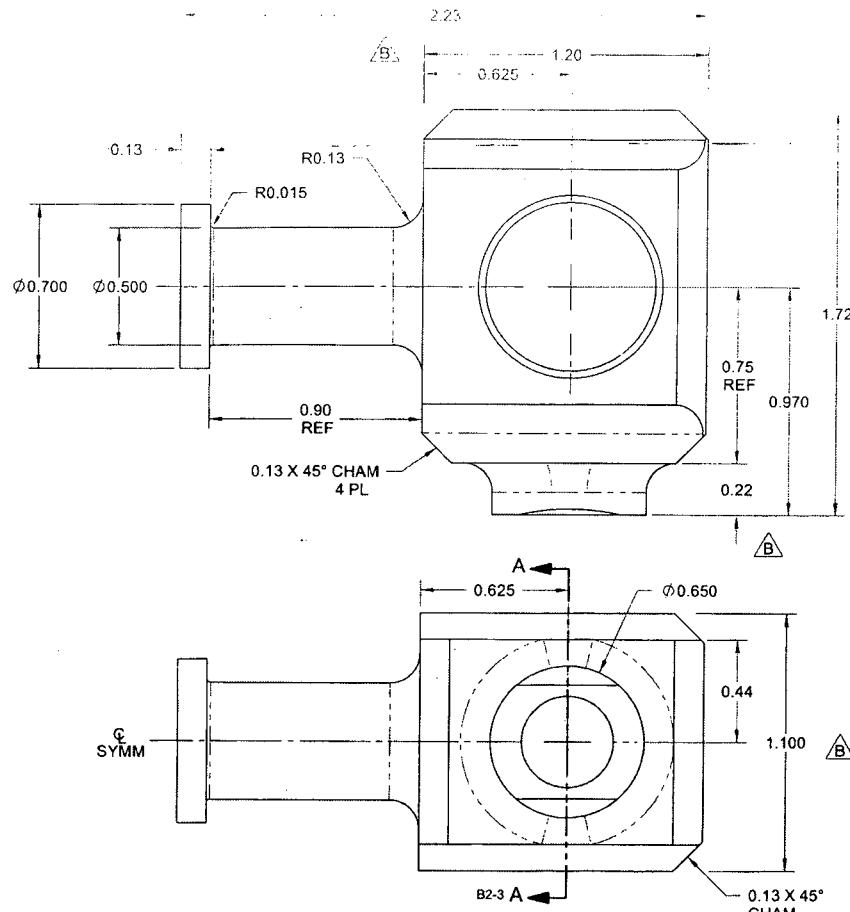
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

8 7 6 5 4 3 2 1

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER; NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.		JPH	10.06.28
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	11S	DART AEROSPACE LTD		
DRAWN	11	HAWKESBURY, ONTARIO, CANADA		
CHECKED	11	DRAWING NO.		REV. B
MFG. APPR.	11	D3912		SHEET 1 OF 3
APPROVED	11	TITLE		SCALE
DE APPR.	11	EYEBOLT RECEIVER ASSY		NTS
DATE	10.06.28			

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD.
IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

103402

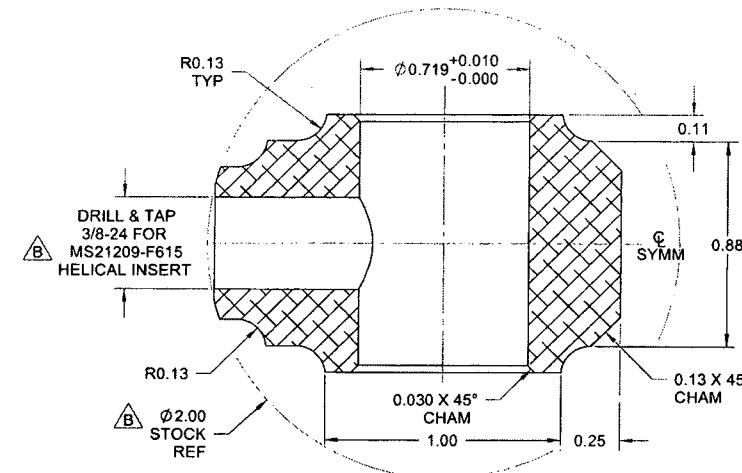


SYMM

D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

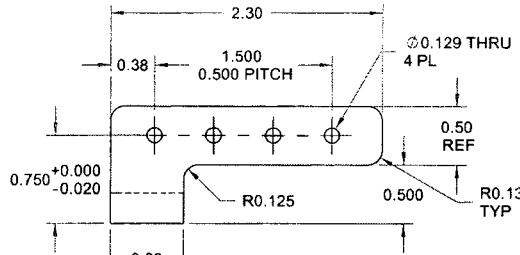
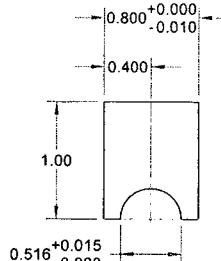
RELEASED
2010-07-16
[Signature]

DESIGN	<i>115</i>	DART AEROSPACE LTD
DRAWN	<i>11</i>	HAWKSBURY, ONTARIO, CANADA
CHECKED	<i>11</i>	DRAWING NO.
MFG. APPR.	<i>11</i>	REV. B
APPROVED	<i>11</i>	D3912
DE APPR.	<i>11</i>	SHEET 2 OF 3
DATE	10.06.28	TITLE
		SCALE
		EYEBOLT RECEIVER ASSY
		NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY OTHER PURPOSE, COPIED, REPRODUCED OR DISCLOSED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

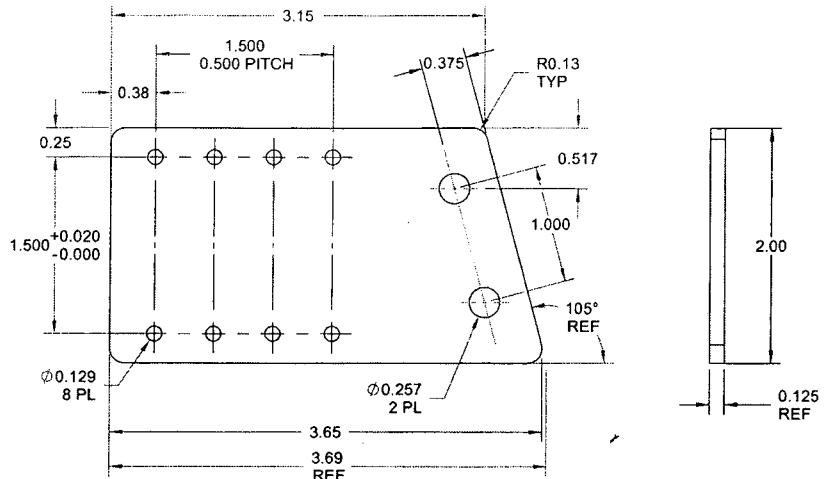
8 1 7 6 5 4 3 2 1

103402

**D3912-3 EYEBOLT BLOCK****NOTES:**

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

8 7 6 5 4 3 2 1

**D3912-5 EYEBOLT PLATE**

RELEASED
2010-07-16
[Signature]

DESIGN	A/S	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. B
MFG. APPR.	<i>[Signature]</i>	DRAWING NO. D3912
APPROVED	<i>[Signature]</i>	SHEET 3 OF 3
DE APPR.	<i>[Signature]</i>	TITLE EYEBOLT RECEIVER ASSY
DATE	10.06.28	SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.